

Date: Monday, 15/12/2008 10:25:31 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE
Job Number	: 44081		
Estimate Number	: 11555		
P.O. Number	:	Part Number	: D30811
This Issue	: 15/12/2008 S.O. No. :	Drawing Number	: D3081 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 26790	Material	:
Written By	:	Due Date	: 22/12/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>MF 08-12-15.</u>		
Comment	: Est A 02.04.26 New Issue NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MS2025757200	Piano Hinge
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Comment: Qty.: 0.3333 Each(s)/Unit Total: 3.3330 Each(s)
 HINGE

Pick:

Qty Part number Description Batch

1 MS2025757200 Continuous hinge 6ft

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Cut hinge as per dwg (approx 26 pieces) and drill as per dwg D3081.
 Deburr.
 Bend hinge as per dwg D3081.

CP 09/01/22

CP 09/01/22 (10)

SB 09/05/14 (10)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

mm1472

S 09/05/14

(10)

4.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
 Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
 Break hinges immediately after powder coat.

(X10)

START TIME:

13:30

OVEN TEMPERATURE:

300°

FINISH TIME:

14:00

UMD

09/05/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE

Job Number: 44081

Part Number: D30811

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BF 09-05-14 *10*

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Sylvie

88 09/05/14 (XO)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/14

Job Completion



mf 09-05-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

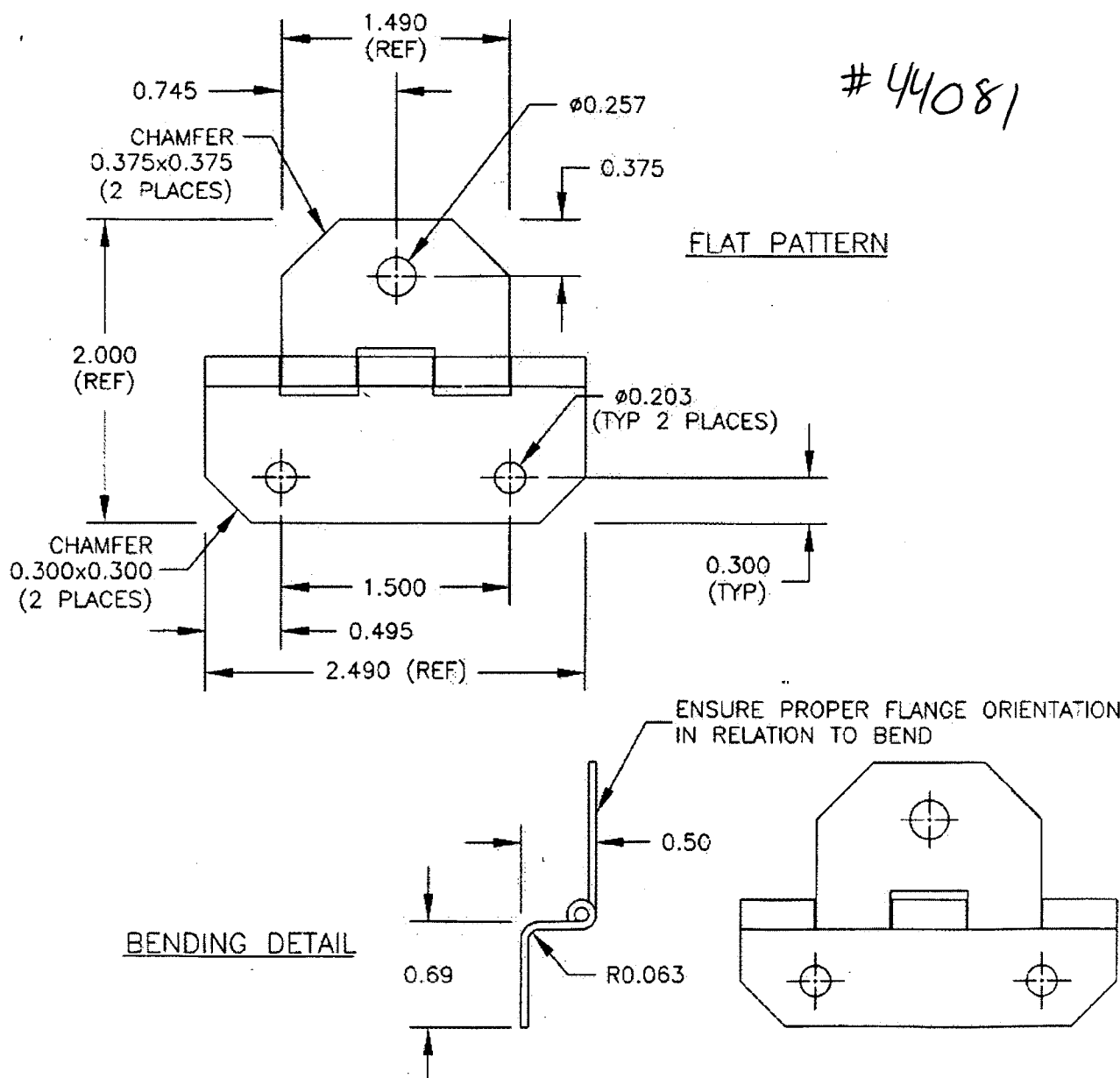
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3081	REV. A SHEET 1 OF 1
DATE 02.01.18		TITLE HINGE	SCALE 1:1
A	02.01.18	NEW ISSUE	



D3081-1 HINGE

MAKE FROM MS20257-5 CONTINUOUS HINGE

BREAK SHARP EDGES 0.015 MAX

FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

RELEASED
02.01.25

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